



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada
Tel (613) 632-5200

fresh

5065337

D4776-5

Job Sheet 176033



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/19/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	4/18/18	4/18/18	0.00	0.00	Start Up Machining-3		<i>MIP 18/04/25</i>
100	Doosan	60 pcs	4/18/18	4/18/18	0.05	3.35	Doosan		<i>MIP 18/04/25</i>
120	QC	60 pcs	4/18/18	4/18/18	0.00	0.00	QC8		<i>D.P. 18-04-26</i>
130	HandFinish	60 pcs	4/19/18	4/19/18	0.00	0.29	HandFinish1		<i>SA 18-04-27</i>
140	QC	60 pcs	4/19/18	4/19/18	0.00	0.00	QC7-4		<i>38</i>
150	Packaging	60 pcs	4/19/18	4/19/18	0.00	0.00	Packaging3-2		<i>AT 18-04-27</i>
160	QC21-SA	60 Ea	4/19/18	4/19/18	0.00	0.00	QC21	<i>DAS 21 9-89</i>	<i>APR 27 2018</i>

Part Op Descriptions: 100 - 1-Turn as per Folio and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 <i>0.130</i> 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 <i>0.250</i> 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 <i>0.625</i> 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 <i>0.435</i> 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 <i>0.204</i> 0.202	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition																			
				Completed By																			
				Lead hand / Supervisor Approval Verification																			
				QC / QA Coordinator Approval																			

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Date: 04/25/18



Container No: S065339
 Part: D4776-5
 Job No: 176033
 Serial No/Batch: S065339
 Revision:
 Inspector:



FAULT CATEGORY

e	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
Defect	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
plete/Unqualified	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence